

SHIP 16/10

Dart Aerospace Ltd.

42

Date: Wednesday, 10/10/2007 10:59:36 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ELECTRIC STEP BUSHING KIT
Job Number : 35058
Estimate Number : 12987
P.O. Number : N/A Part Number : DSI 9374011
This Issue : 10/10/2007 S.O. No. : N/A Drawing Number : DSI 9374 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : 10/10/2007 Type : MACHINED PARTS Drawing Revision : A
Previous Run : 35002 Material : N/A
Due Date : 10/17/2007 Qty: 2 Um: Each
Written By :
Checked & Approved By : 07.10.10
Comment : Est Rev: A New Issue 07-08-10 JLM Verified By: EC

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPDSI 9374-011 CHG 001

KS 07.10.10 (2)

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D36201 BUSHING



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

BUSHING

Batch: 335004

4.0 AN653 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M10 5289

5.0 AN3106 Castellated Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Castellated Nut

Batch: M105279

KS 07/10/12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 10:59:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ELECTRIC STEP BUSHING KIT

Job Number: 35058

Part Number: DSI 9374011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M104745 -

7.0

MS24665300

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cotter Pin

Batch: M105279 -

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP DSI9374-011 CHG 001

Location:

PPP Rev: Draft

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.18.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D412-673 REV. A

REF. CANADIAN STC: SH96-88

REF. FAA STC: SR00563NY

DSI-9374-011 Electric Step Bushing Kit was created to prevent possible wear of the D205-634-011 Skidtube Kit and/or loosening of the ALS7 inserts (provided in the D412-673-011 Electric Step Kit) during normal operation of the BHT 212-706-105-003 Electric Step. The DSI kit replaces the existing ALS7 inserts and hardware with qty(4) D3620-1 Bushings and associated hardware.

- 1) Disconnect the BHT 212-075-418-001 and/or BHT 212-075-418-003 Actuators from the Dart D205-634-011 Skidtube Kit per the Aircraft Maintenance Manual. Remove and discard the qty(4) BHT 212-030-119-001 bolts that fasten then BHT 212-030-309-001 and BHT 212-030-310-001 Arms to the skidtube as shown in **Figure 1** and temporarily move the electric step away from the skidtube.
- 2) Drill out the qty(4) ALS7-428-165 inserts installed in the skidtube at the two locations shown in **Figure 1**. Drill a $\varnothing 0.406$ " pilot hole through the insert holes and the web in the centre of the skidtube. Enlarge the holes to $\varnothing 0.438^{+0.006}_{-0.000}$ ". Deburr and touch up the holes per ICA-D205-634.
- 3) Install the D3620-1 Bushings into each hole (4 places) with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant as shown in **Section A-A**.
- 4) Re-install the electric step by connecting the BHT 212-030-309-001 and BHT 212-030-310-001 Arms as shown in **Section A-A**. Ensure all nuts are installed on the inboard side of the skidtube. Re-attach the BHT 212-075-418-001 and/or BHT 212-075-418-003 Actuators to the skidtube per the Aircraft Maintenance Manual.

Parts List:

Qty -011	Part Number	Description
X	DSI-9374-011	Electric Step Bushing Kit
4	D3620-1	BUSHING
2	AN6-53*	BOLT (OR AN6C53*)
2	AN310-6	CASTELLATED NUT (OR AN310C6)
4	AN960JD616	WASHER (OR AN960C616)
2	MS24665-300	COTTER PIN (OR AN380C3-3)

* It is acceptable to replace the AN6 bolts with longer or shorter AN6 bolts as required and/or install extra AN960JD616 washers under the nut to ensure proper installation of the cotter pin.

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 35058

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 07.07.19

CERT. NO.: SH96-88

ISSUE NO.: 3

A	NEW ISSUE	CB	07.07.19
REV.	DESCRIPTION		BY DATE
DESIGN	CB	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9374	SHEET 1 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ELECTRIC STEP BUSHING KIT	NTS
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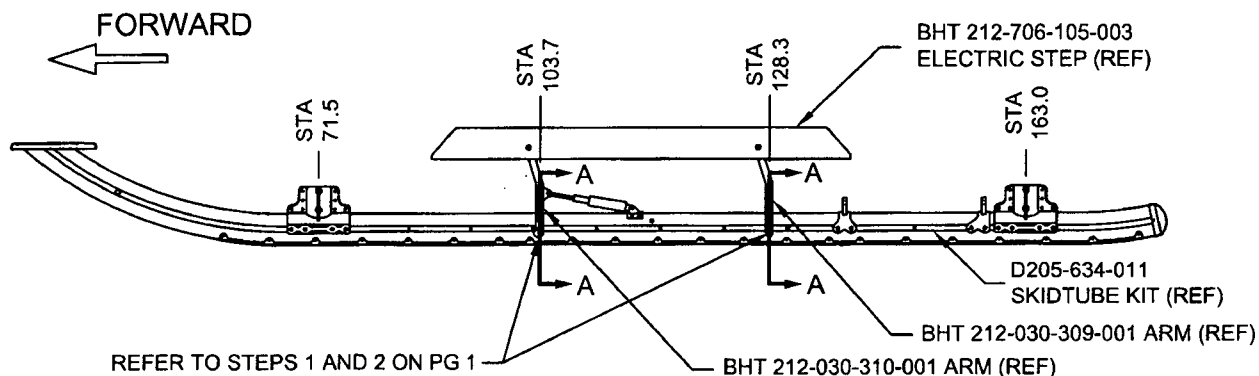
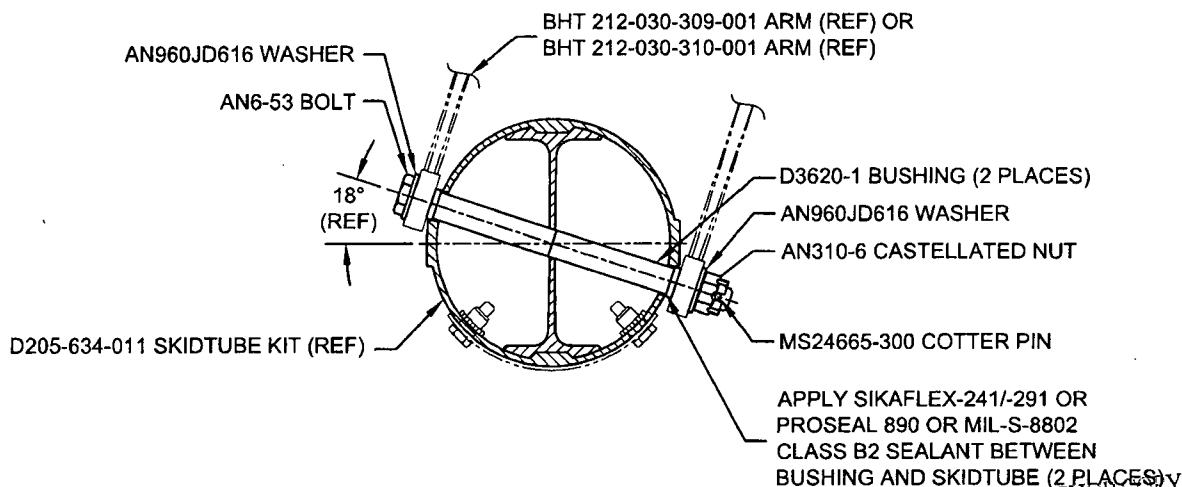


FIGURE 1 - TYPICAL BHT ELECTRIC STEP INSTALLATION

(REFER TO STEPS 1 AND 2 ON PG 1)



SECTION A-A
(REFER TO STEPS 3 AND 4 ON PG 1)

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *D. Shepherd*
D. SHEPHERD (DE # 02)
DATE: 07.07.19
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9374	SHEET 2 OF 2
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